

Work Order ID 116370

Monday, April 14, 2014 9:29:17 AM

116370

Page 1

Item ID: D350-588-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Aft Door Assembly
Start Date: 4/14/2014 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 5/30/2014 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: CL Date: 14/04/14 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr	<u>JB</u>							
D2445/D350-588	Rev D/D								

100 Document Control 0.00
100 DOCUMENT CONTROL
DC Memo 0.00
Doc.Control -USB or Paperwork Photocopy bluefile and create labels per PPP D350-588-041 CHG003

JUN 04 2014

DAS
06
9-89ML2 14-05-30

110 PURCHASING 0.00
110
Purchasing Memo 0.00
Purchasing Issue P/O: 23807
Description: D2445 Baggage Door
Supplier: Delastek
Ship to Delastek (1) D0588-041 label
Certification of Conformity and process sheet from Delastek is required.

CL 14/04/15 ①

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Item ID: D350-588-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Aft Door Assembly

Start Date: 4/14/2014 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 5/30/2014 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

Receive & Inspect for Damage & Mat'l Certs

0.00

120

Packaging

Memo

0.00

Packaging

Ensure Certificate of Conformity & Process Sheet are attached

14/0/26 C

130

QC6- Inspect dimensions to drawing

0.00

130

QC

Memo

0.00

Quality Control

Inspect as per Dwg D2445.
Audit process sheet.

DAS
27
4-89
14/5/27

140

Small Fab

0.00

140

Small Fab

Memo

0.00

Small Fab

Assemble all of the above parts as per Dwg D350-588

1 14-05-30

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Item ID: D350-588-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Door Assembly

Start Date: 4/14/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/30/2014 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control

155

Pick Kit

0.00

155

Packaging

Memo

0.00

Packaging

160

QC4- 100% Inspect kits for completeness

0.00

160

QC

Memo

0.00

Quality Control

DAS
06
9-89

JUN 04 2014

DAS
33 14-05-30
9-89

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Item ID: D350-588-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Door Assembly

Start Date: 4/14/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/30/2014 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Identify as per dwg & Stock Location: 031A

0.00

170

Packaging

Memo

0.00

Packaging

JAS
16
2

JUN 04 2014



180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

MCS 14-06-04

MF
14-6-4

Monday, April 14, 2014 9:29:16 AM

1 16370

D350-588-041

Required Qty: 1.00

IPP Rev:Q as
IPP Rev:R add pick kit DD

600

14-05-30

**

13

DAS
31
9-89

128429

Picklist Print

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Page 2

Work Order ID: 116370

116370

Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 4/14/2014

Required Date: 5/30/2014

Start Qty: 1.00

Required Qty: 1.00

D2143

Manufactured No

140

Each

22.0000

1

**

DAS

33

9-89

D2143

Hinge Bracket

Location

Loc Qty

Loc Code

ST005

22

100918

12

108818

7

98391

3

100918

D2144

Manufactured No

140

Each

21.0000

1

**

DAS

33

9-89

D2144

Hinge Doubler

Location

Loc Qty

Loc Code

ST005

21

100467

21

100467

D2150

Manufactured No

155

Each

16.0000

2

**

DAS

33

9-89

D2150

Packer Doubler, Hinge

68-6

90

9-89

DAS

06

9-89

Location

Loc Qty

Loc Code

ST005

16

112962

16

106861

D2151

Manufactured No

155

Each

34.0000

2

**

DAS

33

9-89

D2151

Packer Doubler

DAS

06

9-89

Location

Loc Qty

Loc Code

ST005

34

102125

2

106821

32

114304

14-06-04

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Shop Packet Print

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Work Order ID: 116370

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Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 4/14/2014

Required Date: 5/30/2014

Start Qty: 1.00

Required Qty: 1.00

D2153 Manufactured No

155

Each

60.0000

1 1

DAS

33

9-89

D2153

Door Prop

DAS
06
9-89

Location

Loc Qty

Loc Code

FG

4

85865

4

ST260

56

100934

5

110755

18

114286

33

100934

DAS
33
9-89

D2154 Manufactured No

155

Each

11.0000

1

DAS

33

9-89

D2154

Bracket, Stud

DAS
06
9-89

Location

Loc Qty

Loc Code

ST006

11

100839

11

110134

DAS
33
9-89

D2237 Manufactured No

155

Each

60.0000

2 2

DAS

33

9-89

D2237

Striker Plate

DAS
06
9-89

Location

Loc Qty

Loc Code

ST007

60

108708

20

112911

40

112911

DAS
33
9-89

D2445P Purchased No

110

Each

0.0000

1

D2445P

Aft Door Assembly

**

116370

14-06-04

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Work Order ID: 116370

116370

Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 4/14/2014

Required Date: 5/30/2014

Start Qty: 1.00

Required Qty: 1.00

D2461 Manufactured No 155 f

674.9700 7.25 8

DAS

33

9-89

14-06-04

D2461
Seal (Per Foot) DAS

DAS 06 27
9-89 9-89

Location

Loc Qty

Loc Code

ST402

674.97

102517

174.97

114238

500

114238

DAS

33

9-89

(D2461-0870) cut (1) at 87.00"
**** per kit****

D2463 Manufactured No 140 f

341.6337 7.25 8

DAS

33

9-89

D2463

1/2" Seal (\$Per Foot) DAS

14 87" 27
9-89 9-89

Location

Loc Qty

Loc Code

ST402

341.633684

110718

341.633684

110718

(D2463-0870) cut (1) at 87.00"
**** per kit****

D2585 Manufactured No 140 Each

65.0000 2 2

DAS

33

9-89

14-05-30

D2585

Latch Clamp

Location

Loc Qty

Loc Code

ST012

65

108520

1

110344

3

112571

19

112974

14

114114

28

114114

Picklist Print

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Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 4/14/2014

Required Date: 5/30/2014

Start Qty: 1.00

Required Qty: 1.00

D2586

Manufactured No

140

Each

47.0000

2 2

D2586

Door Latch

**

114985

DAS

33

9-89

Location

Loc Qty

Loc Code

FG

13

100607

2

83893

10

95760

1

ST198A

34

108573

24

113641

10

D2589

Manufactured No

155

Each

21.0000

1 1

D2589

Keys, Key Chain

**

DAS

33

9-89

14-06-04

Location

Loc Qty

Loc Code

ST012

21

58194

21

58194

DAS

33

9-89

D2621

Manufactured No

140

Each

48.0000

2 2

D2621

Latch Plate

**

DAS

33

9-89

14-02-30

Location

Loc Qty

Loc Code

FG

2

88616

2

ST013

46

108138

3

115195

43

115195

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Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 4/14/2014

Required Date: 5/30/2014

Start Qty: 1.00

Required Qty: 1.00

D2690-17

Manufactured No

155

Each

33.0000

1

**

DAS
33
9-89

D2690-17

Cable

Location

Loc Qty

Loc Code

ST016

33

100752

3

108397

5

110028

6

112206

6

114912

12

94470

1

108397

DAS
33
9-89

DAS
06
9-89

D2857-1

Manufactured No

140

Each

44.0000

1

**

DAS
33
9-89

D2857-1

Hinge Bracket

Location

Loc Qty

Loc Code

FG

5

82261

4

91914

1

ST019

39

106185

3

110247

12

113744

24

110247

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Work Order ID: 116370

116370

Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 4/14/2014

Required Date: 5/30/2014

Start Qty: 1.00

Required Qty: 1.00

D2857-2

Manufactured No

140

Each

52.0000

1

1

DAS

D2857-2

Hinge Bracket

**

33
9-89

14-02-30

Location

Loc Qty

Loc Code

FG

3

78904

3

ST019

25

100769

1

108401

24

ST024

24

114154

24

108401

D2858-1

Manufactured No

155

Each

46.0000

1

DAS
33
9-89

D2858-1

Hinge Bracket

**

Location

Loc Qty

Loc Code

FG

2

77019

2

ST019

44

100756

8

110032

12

114144

24

110032

DAS
31
9-89

D2858-2

Manufactured No

155

Each

44.0000

1

DAS
33
9-89

D2858-2

Hinge Bracket

**

14-06-04

Location

Loc Qty

Loc Code

FG

2

77020

2

ST020

42

105555

18

113735

24

105555

DAS
31
9-89

DAS
06
9-89

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Work Order ID: 116370

116370

Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 4/14/2014

Required Date: 5/30/2014

Start Qty: 1.00

Required Qty: 1.00

FG-778150-550-ROL

Purchased

No

155

sf

2,378.000

1

***FG-778150-550-ROL ***

7781 96z Glass 50x125yd

DAS
06
9-89

Location

Loc Qty

Loc Code

CA

2378

M127570

815

M127701

1563

**

DAS
33
9-89

DAS
31
9-89

127570

CUT ONE SQUARE FEET PER KIT

MS20426AD3-4

Purchased

No

155

Each

7,961.000

12

MS20426AD3-4

RIVET

DAS
06
9-89

Location

Loc Qty

Loc Code

MF4

365

125578

365

ST334

3192

m127432

3192

ST509

4404

125578

4404

**

DAS
33
9-89

DAS
31
9-89

125578

MS20470AD4-5

Purchased

No

155

Each

4,029.000

18

MS20470AD4-5

RIVET, UNIVERSAL HEAD

DAS
06
9-89

Location

Loc Qty

Loc Code

GA

7

m126926

7

ST336

4022

m126926

716

m128401

1653

m128813

1653

**

DAS
33
9-89

DAS
31
9-89

128813

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Work Order ID: 116370

116370

Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 4/14/2014

Required Date: 5/30/2014

Start Qty: 1.00

Required Qty: 1.00

MS21042L08

Purchased

No

140

Each

6,190.000

8

8

MS21042L08

Nut

DAS
33
9-89

14-05-30

Location

Loc Qty

Loc Code

ST314

3558

123900

58

m128401

1500

m128429

2000

ST508

2533

125445

1135

m127410

1398

ST509

99

m127304

99

128429

MS21042L08

Purchased

No

155

Each

6,190.000

10

10

MS21042L08

Nut

DAS
33
9-89

14-06-03

Location

Loc Qty

Loc Code

ST314

3558

123900

58

m128401

1500

m128429

2000

ST508

2533

125445

1135

m127410

1398

ST509

99

m127304

99

128429

DAS
06
9-89

DAS
31
9-89

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Work Order ID: 116370

116370

Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 4/14/2014

Required Date: 5/30/2014

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

140

Each

8,800.000

2

2

MS21042L3

Nut

DAS
33
9-89

14-65-30

Location

Loc Qty

Loc Code

ST314

1845

M127410

804

M127831

41

M128401

1000

ST506

955

123900

955

ST509

6000

M128754

6000

128754

MS21042L3

Purchased

No

155

Each

8,800.000

4

MS21042L3

Nut

DAS
33
9-89

14-06-03

Location

Loc Qty

Loc Code

ST314

1845

M127410

804

M127831

41

M128401

1000

ST506

955

123900

955

ST509

6000

M128754

6000

128754

DAS
06
9-89

DAS
31
9-89

Picklist Print

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Work Order ID: 116370

116370

Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 4/14/2014

Required Date: 5/30/2014

Start Qty: 1.00

Required Qty: 1.00

MS27039-08-11

Purchased

No

155

Each

544.0000

2

MS27039-08-11

SCREW

**

DAS

14-06-03

33

9-89

DAS
06
9-89

Location

Loc Qty

Loc Code

ST307

18

123352

18

ST506

526

122441

37

123185

1

123900

88

M128770

400

122441

DAS
31
9-89

MS27039-1-15

Purchased

No

140

Each

1,027.000

2

2

MS27039-1-15

Screw

**

DAS

33

9-89

Location

Loc Qty

Loc Code

ST306

427

124326

427

ST506

600

m127916

600

124326

NAS1149D0363J

Purchased

No

140

Each

5,383.000

2

2

NAS1149D0363.J

Washer

**

DAS

33

9-89

14-05-30

Location

Loc Qty

Loc Code

GA

23

124392

23

ST510a

5360

m126319

130

m127813

230

m128429

5000

128429

DAS
31
9-89

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Work Order ID: 116370

116370

Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 4/14/2014

Required Date: 5/30/2014

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0363J

Purchased

No

155

Each

5,383.000

2

NAS1149D0363.I

Washer

**

DAS

33

9-89

14-06-03

DAS
06
9-89

Location

Loc Qty

Loc Code

GA

23

124392

23

ST510a

5360

m126319

130

m127813

230

m128429

5000

128429

NAS1149DN832J

Purchased

No

140

Each

2,506.000

8

8

NAS1149DN832.I

Washer

**

DAS

33

9-89

128948

14-05-30

Location

Loc Qty

Loc Code

MF4

912

M127255

912

ST293

1432

M127813

432

M128429

1000

st510

145

124555

145

ST510a

17

M126319

17

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Work Order ID: 116370

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Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 4/14/2014

Required Date: 5/30/2014

Start Qty: 1.00

Required Qty: 1.00

NAS1149DN832J

Purchased

No

155

Each

2,506.000

16

NAS1149DN832J

Washer

**

128948

DAS

33

14-06-03

9-89

DAS
06
9-89

Location

Loc Qty

Loc Code

MF4

912

M127255

912

ST293

1432

M127813

432

M128429

1000

st510

145

124555

145

ST510a

17

M126319

17

DAS
31
9-89

DAS
06
9-89

DAS
10
9-89

5080-041 x2

6119725

7.10

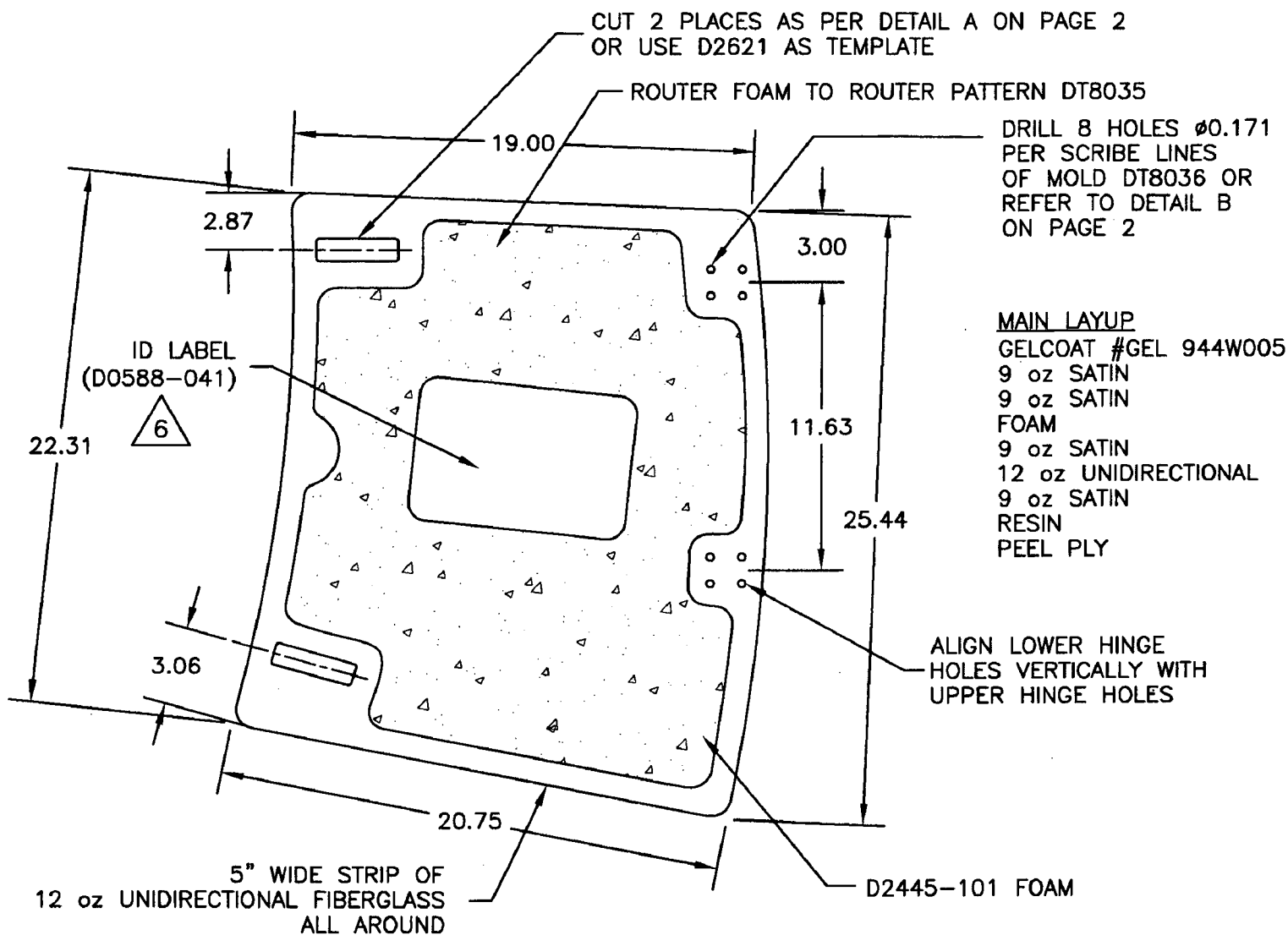
8

DART

JB		CB		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.		REV. D	
		D2445		SHEET 1 OF 2	
DATE		TITLE		SCALE	
06.06.09		AFT BAGGAGE DOOR		1:7	
A	97.07.15	NEW ISSUE			
B	02.01.24	ADD D2621; D2445-101			
C	04.02.09	REMOVE D2621; UPDATE NOTES			
D	06.06.09	ADD DIMENSIONS TO PERIMETER			

RELEASED

06.11.13

**NOTES:**

- 1) USE MOLD DT8036 FOR DOOR LAYUP. TRIM AND DRILL PER DT8619
- 2) RESIN: DERAKANE 411/510A40/470-36
- 3) FOAM: 3/8" A500 CORE CELL OR DIVINYLCELL OR AIREX OR KLEGECELL R-75
- 4) FIBRE: 9.7 oz 7781 WEAVE "S" GLASS ("9 oz SATIN")
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
- 5) BOND FOAM CORE TO LAMINATE USING POLYBOND B46F
- 6) LAMINATE LABEL USING SURFACE VEIL AND EPOXY RESIN.
- 7) LAMINATE PER DART QSI 006 4.0
- 8) LAMINATION SCHEDULE PER THIS DRAWING
- 9) FINISH INSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 10) ALL DIMENSIONS ARE IN INCHES
- 11) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

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C214/04/114

W10: 116370

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>
--	--	---

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

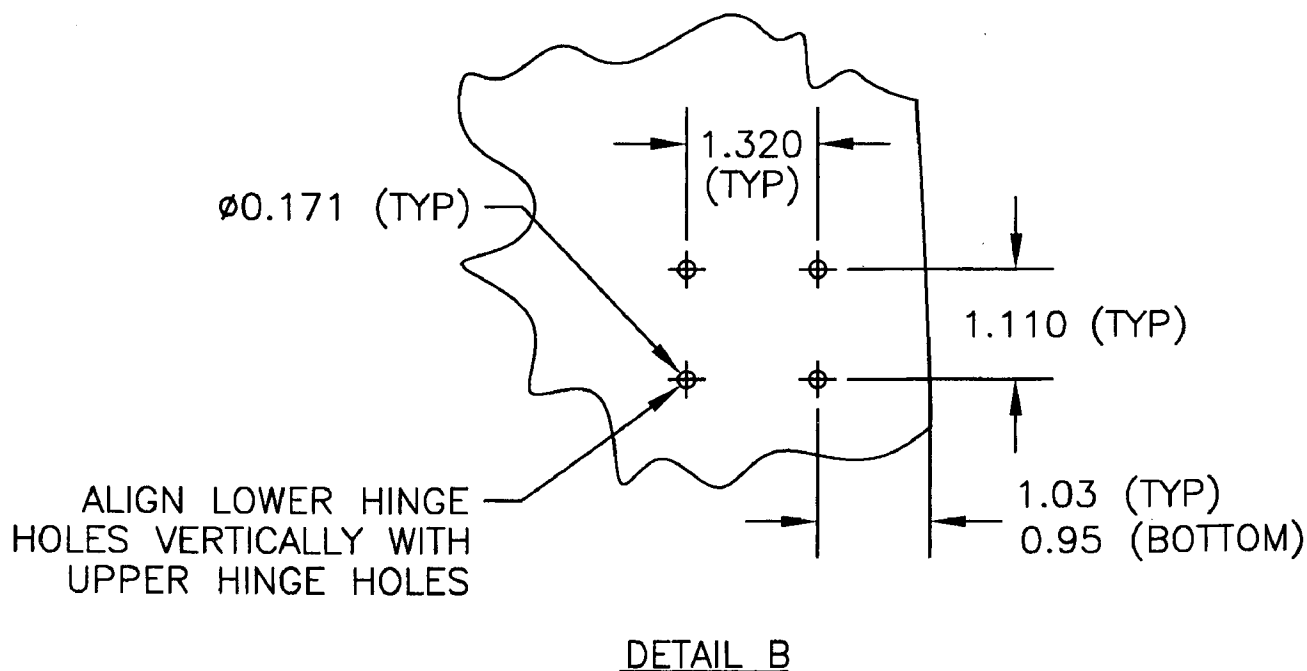
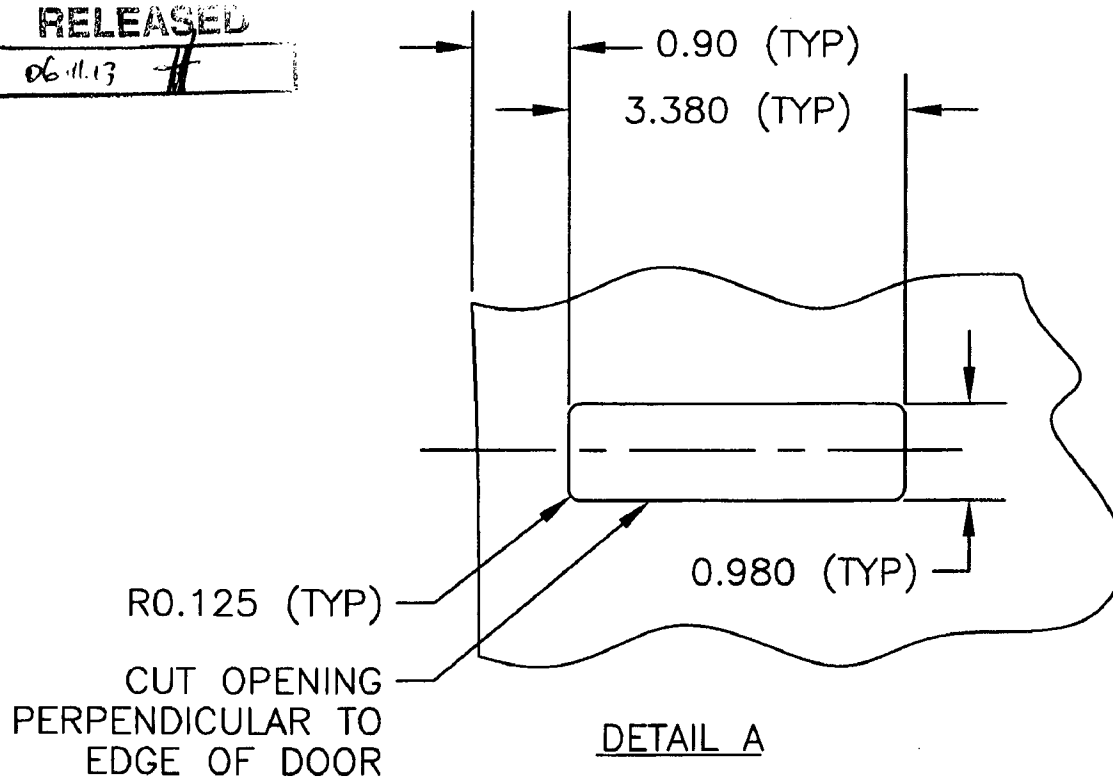
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
--	--	---	--



DESIGN JB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2445	REV. D SHEET 2 OF 2
DATE 06.06.09		TITLE AFT BAGGAGE DOOR	SCALE 1:2

RELEASED

06.11.13 *[Signature]*



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DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Folio/Program
<input type="checkbox"/> Centre Not Concentric	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Grain
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damage/Defect	<input type="checkbox"/> Hardware
<input type="checkbox"/> Crimp/Kink/Ripple/Wave	<input type="checkbox"/> Burrs	<input type="checkbox"/> Inspection Incomplete/Unqualified
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Crushing	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misaligned/off center
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Mislabeled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Drawing	<input type="checkbox"/> Misread
<input type="checkbox"/> Marks/Chatter	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Off-set
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Fit/Function	<input type="checkbox"/> Out of Sequence
		<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Set-up
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other

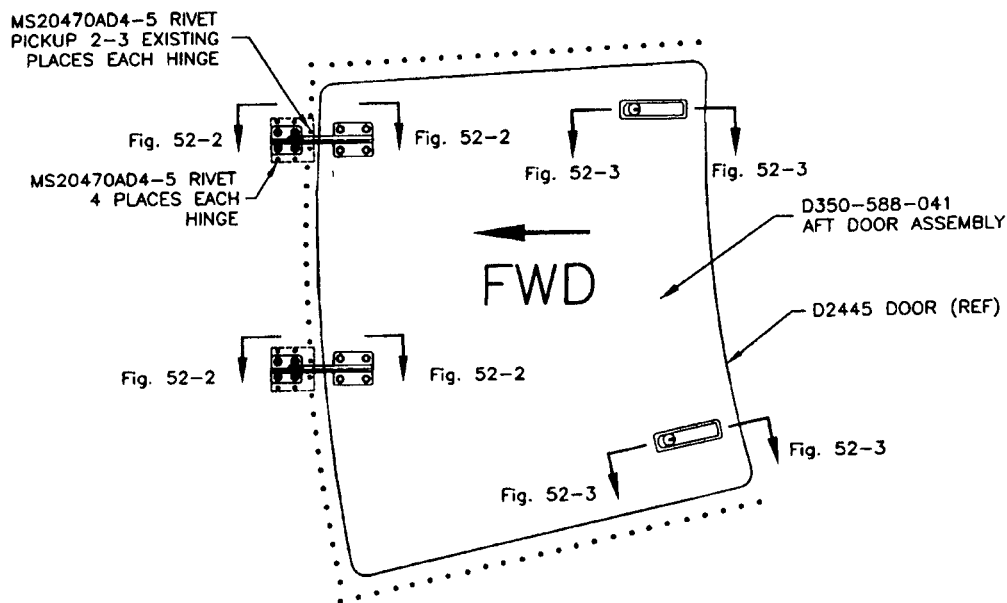


Figure 52-1: Baggage Door Outside View

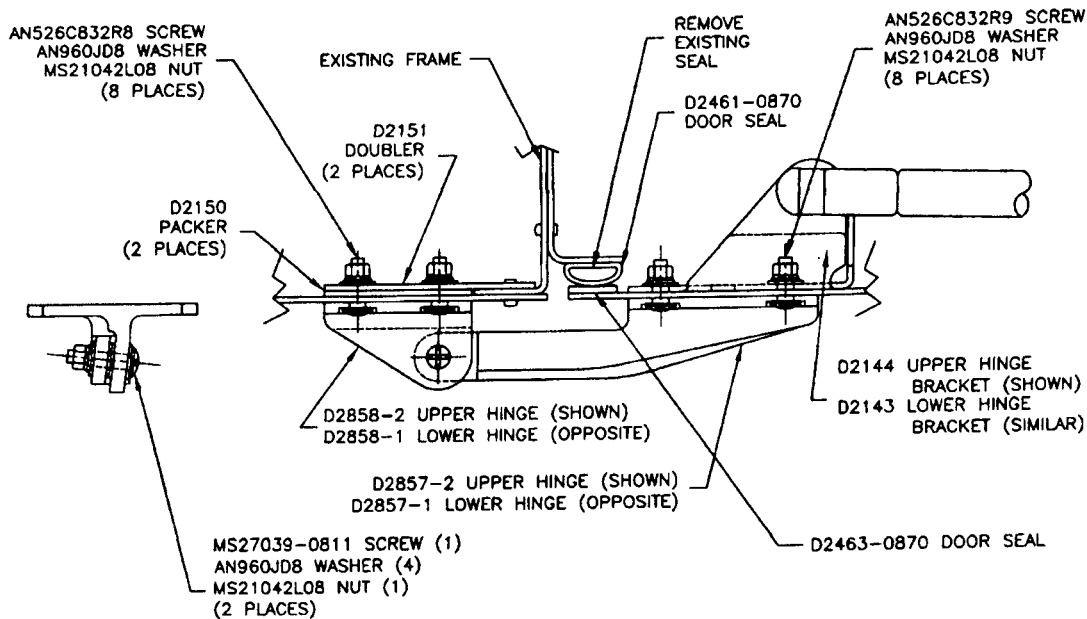


Figure 52-2: Hinge Detail

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52-00-00

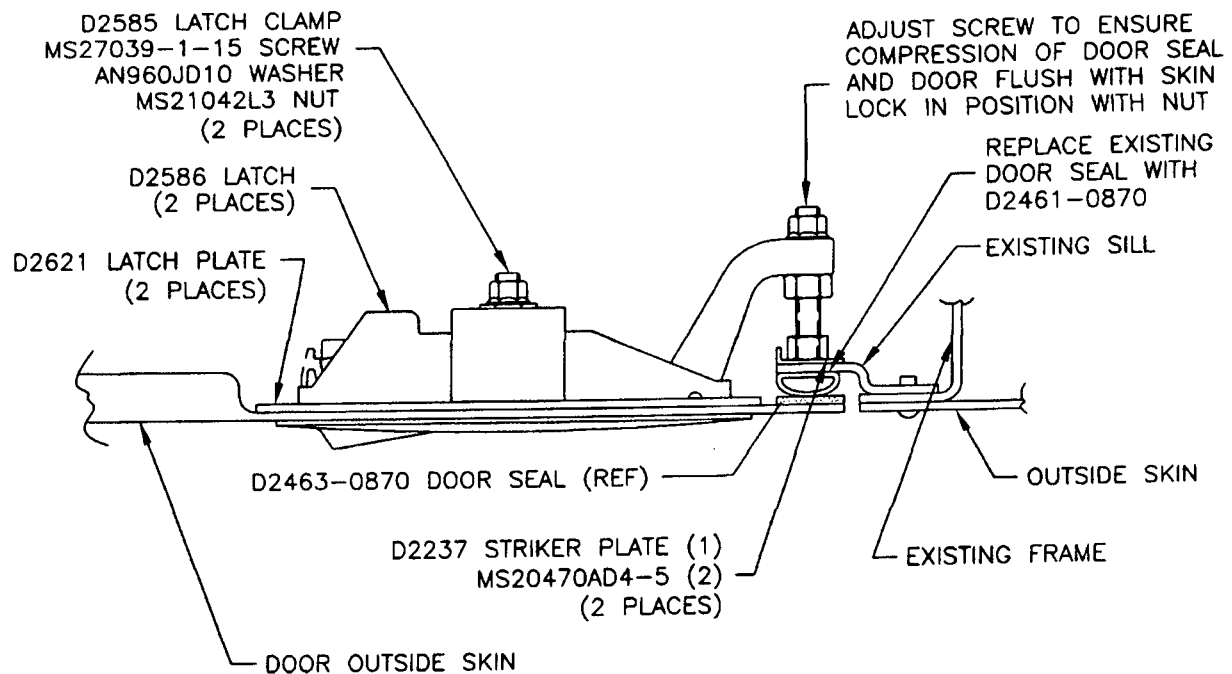


Figure 52-3: Latch Section

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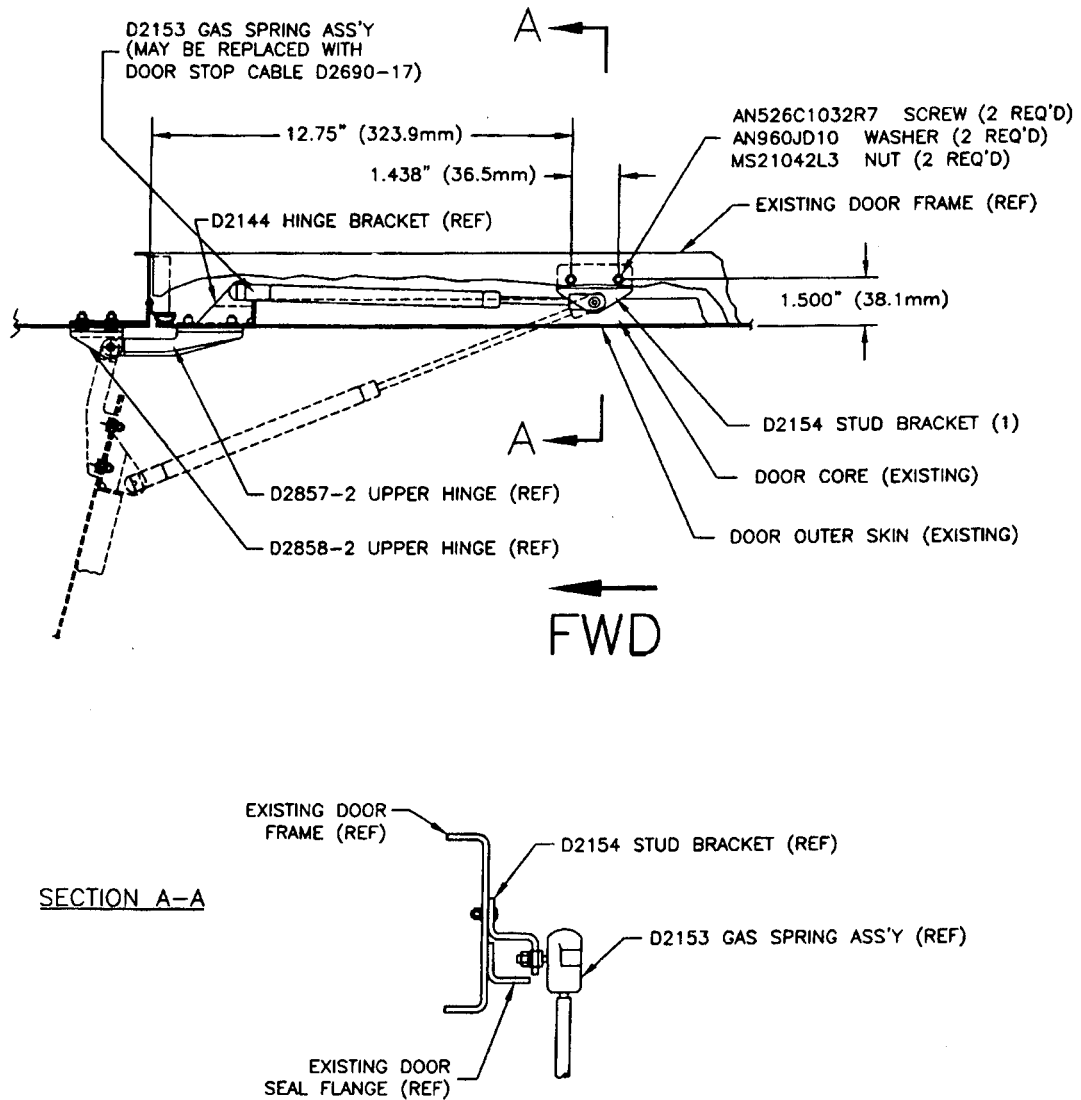


Figure 52-4: Gas Spring Installation

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52-00-00

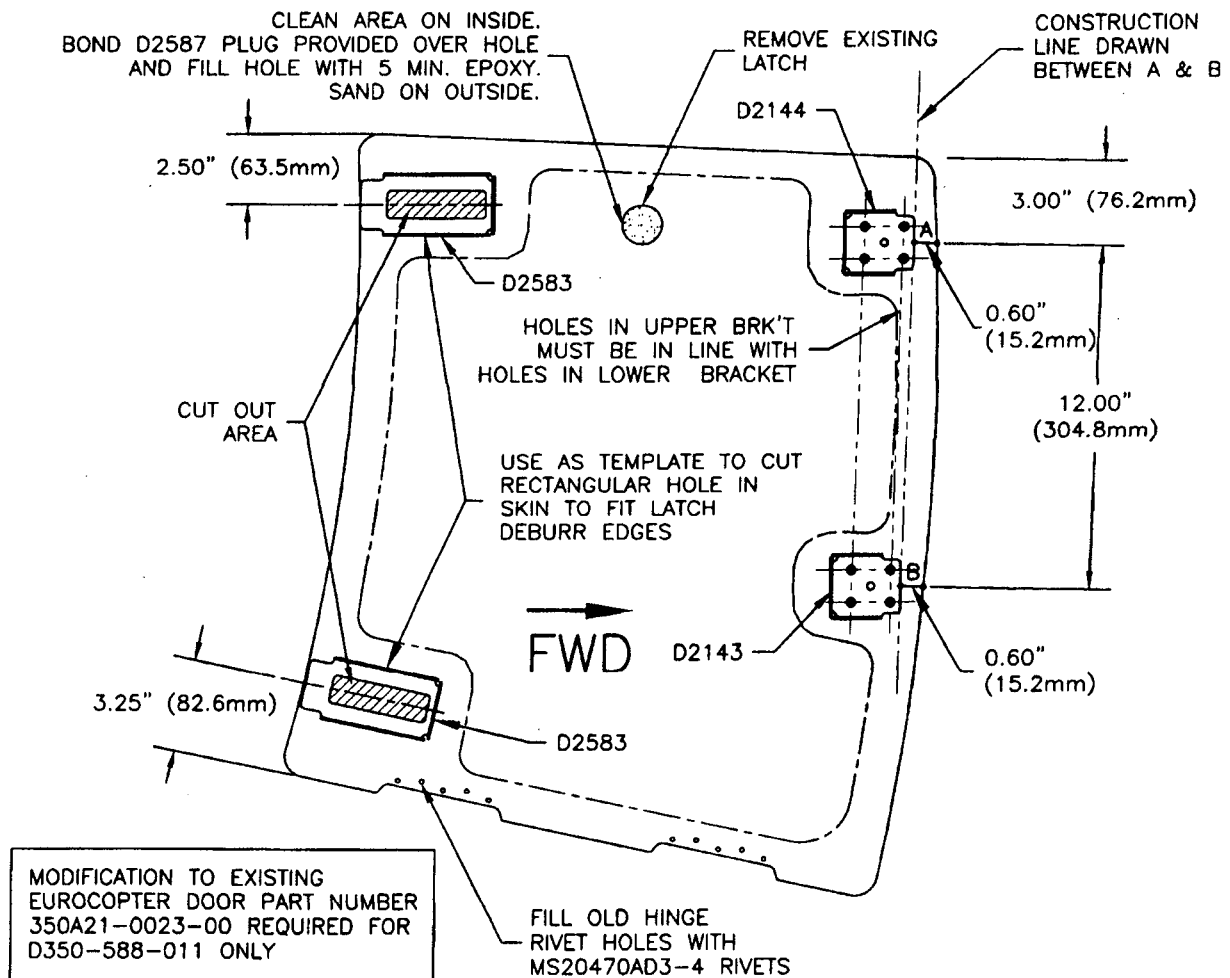


Figure 52-5: Baggage Door Inside View

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52-00-00

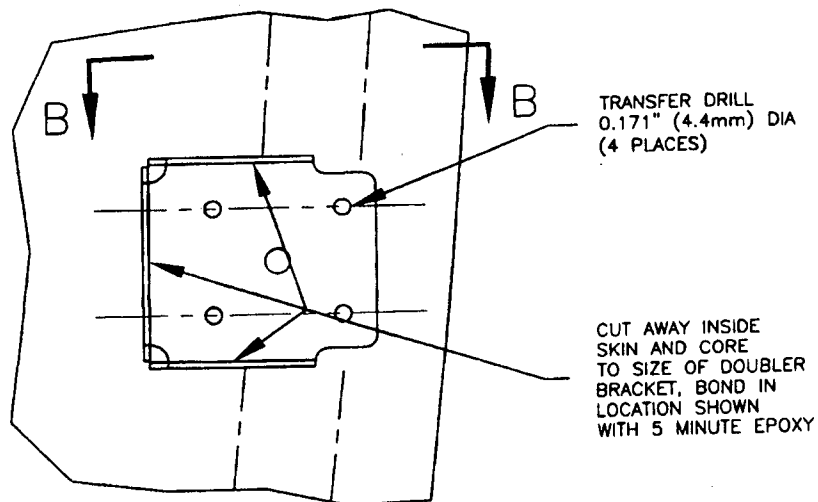
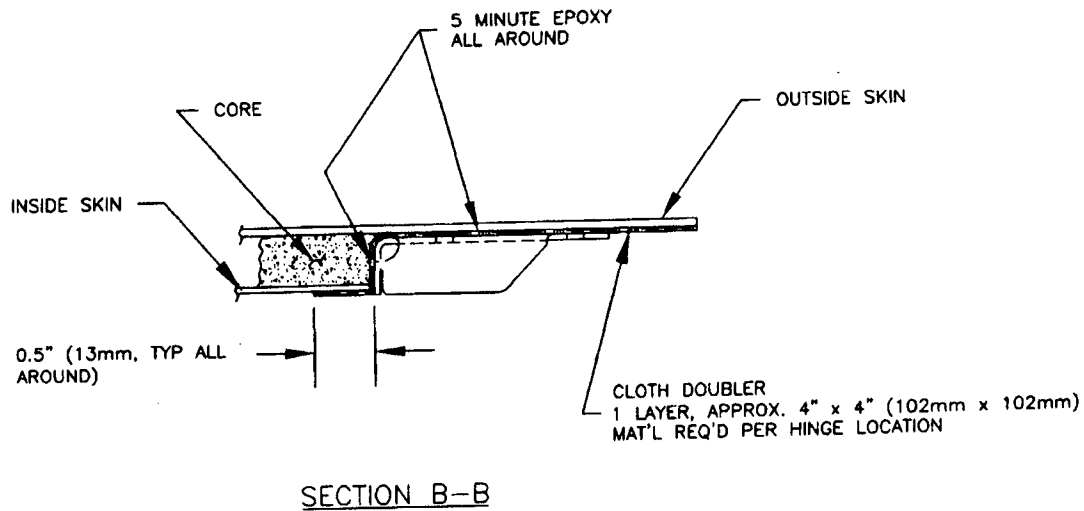


Figure 52-6: Typical Doubler Bracket Installation

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52-00-00



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO23807

Purchase Order Date 4/15/2014

PO Print Date 4/15/2014

Page Number 2 of 3

Order From :
DELASTEK INC
2699 5E AVENUE, LOCAL C.P 10100

GRAND-MERE, QC G9T 5K7
CA

VU-DEL003

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 819 533 5788

Ship To Contact
Ship To Phone
Ship Via: FedEx PI collect
Ship Acct:

Buyer
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency USD
FOB FCA - (Free Carrier)

Chantal Lavoie

Line Total: \$592.76

4 D2445P Aft Door Assembly

5/30/2014

Yes

5/30/2014

1.00

Each

\$592.76

\$592.76

AS PER DWG D2445 REV. D
B116370

Line Total: \$592.76

5 D2445P Aft Door Assembly

6/10/2014

Yes

6/10/2014

1.00

Each

\$592.76

\$592.76

AS PER DWG D2445 REV. D
B116371

Line Total: \$592.76

6 D2445P Aft Door Assembly

6/10/2014

Yes

6/10/2014

1.00

Each

\$592.76

\$592.76

AS PER DWG D2445 REV. D
B116372

Note:

4/15/2014



DELASTEK Inc.
2699 5e Avenue
Local 14,
Grand-Mère, Québec G9T 2P7
Canada
Tel.: (819) 533-5788
Fax: (819) 533-3494

PACKING SLIP

CERTIFICATE OF COMPLIANCE

Invoice No.	57359
Customer No.	DART US

Bill To

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone : 613-632-5200

Contact : Linda Lacelle

Ship To

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone : 613-632-5200

Contact : Linda Lacelle

Ship Date	Order Date	Our SO #	Ordered by	Your PO#	Terms
23-05-2014	15-04-2014	24538	Chantal Lavoie	PO23807	Net 30 days USA
Ship Via		F.O.B.		Salesperson	GST/PST
FEDEX P1 Collect		Point de départ		Marie-Pier Montambeault, 235	
Order Qty	B.O. Qty	Current Ship.	Item number	Description	
1	0	1	DKC134-0013	Line #4 Aft Baggage Door (D2445) B116370 U of M: Chaque Drawing N° : D2445 Rév.: D DOCUMENT INCLUS Serial # Lot # B116370 61090	

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

Accepted by:

Quality department

AQ-357

☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Date: Mercredi, 2014-04-16 08:14:00
Utilisateur: marc dubé

Feuille de Procédé

4/7 mai

Client : DART US DART AEROSPACE	Nom Dessin : N° D2445, AFT BAGGAGE DOOR
Numéro Job : 61090	Numéro Article : DKC134-0013
Numéro : 3959	Numéro Dessin : D2445
Numéro B.A. :	Projet Numéro : DK-362
Cette fois : 2014-04-16 No. :	Révision dessin : D
Prsht Rev. : NC	Matériel : Composite
Prem. fois : - - Type :	Date Dûe : 2014-06-10
Job précédente : 55240	Qté : 1 Ud UNITE
Écrit par : _____	
Vérifié & Approuvé par : _____	
Commentaires : N° de pièce Client: N/A	



B116370

E.O.: N/A

Feuille de Procédé Rév.: 05 ajout de l'IF134-0007 sur plusieurs séquences, numéro du moule passe de DT-8036 pour DKO-0235, numéro du moule passe de DT-8619 pour DKO-0063, ajouter IF134-0006 pour le taillage

Formulaire d'inspection: N/A

COPIE

Produit additionnel

Numéro Job:



Séq.: Machine ou Description :

1.0 AAC1616 N° 83634, Frekote Loctite Wolo

Comment Qty.: 0.200 UNITE(s)/Unit Total : 0.200 UNITE(s)
N° 83634, Frekote Loctite Wolo # de Lot: 1-42289-1

2.0 PREP-GENERAL Préparation du matériel

**Comment** Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préparation du moule N° DKO-0235 selon IG 0009.

Date: 9/05/14 Sceau:

3.0 AMB0350 Gel Coat Blanc N° Gel 944W005

Comment Qty.: 0.200 KILOGRAMME(s)/Unit Total : 0.200 KILOGRAMME(s)
Gel Coat Blanc N° Gel 944W005 N° de Lot: 1-45003-2

4.0 AMB0286 Catalyst N° DDM-9

Comment Qty.: 0.0320 GALLON(s)/Unit Total : 0.0320 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-27829-1

Date: Mercredi, 2014-04-16 08:14:00

Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE

Nom Dessin: N° D2445-AFT BAGGAGE DOOR

Numéro Job: 61090

Numéro DKC134-0013

Numéro Job:



Séq.:

Machine ou Opération:

Description :

5.0

PREP-GENERAL

Préparation du matériel



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% catalyst par quantité de résine.

Date: 9/05/14 Sceau:



6.0

GEL COAT

Application du Gel Coat



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire l'application du Gelcoat selon IF134-0007

Date: 9/05/14 Sceau:



7.0

AAC1885

Tissu à délaminer Release ply B

Comment Qty.: 1.52 VERGE(s)/Unit Total : 1.52 VERGE(s)
Tissu à délaminer Release ply B # de Lot: N/A

8.0

AAC1887

Wrightlon 5200 Bleu P3

Comment Qty.: 3.33 VERGE(s)/Unit Total : 3.33 VERGE(s)
Wrightlon 5200 Bleu P3 # de Lot: N/A

9.0

AC0885

Feutre de drainage N° Airweave N 10

Comment Qty.: 2.78 VERGE(s)/Unit Total : 2.78 VERGE(s)

10.0

AC0943

Stretchlon 200 poche à vide Vert

Comment Qty.: 2.00 PIED(s)/Unit Total : 2.00 PIED(s)

11.0

AMB0214

9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

Comment Qty.: 2.00 VERGE(s)/Unit Total : 2.00 VERGE(s)
9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

N° de Lot: 1-44353-3

12.0

AMB0511

N° TG-13-U, Fiberglass 13 oz

Comment Qty.: 0.33 VERGE(s)/Unit Total : 0.33 VERGE(s)
N° TG-13-U, Fiberglass 13 oz

N° de Lot: 1-36302-1

13.0

AC0886

Ruban à gommer jaune #: T/AT-200Y

Comment Qty.: 1.2500 ROULEAU(s)/Unit Total : 1.2500 ROULEAU(s)

14.0

PREP-GENERAL

Préparation du matériel

















Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Découper les tissus selon IF134-0007.

Information de référence pour les tissus:

Date: Mercredi, 2014-04-16 08:14:00
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE	Nom Dessin: N° D2445, AFT BAGGAGE DOOR	
Numéro Job: 61090	Numéro DKC134-0013	
Numéro Job: 		
# Séq.:	Machine ou Opération:	Description :
<p>4 plis de tissus de 9.7 oz. 1 pli de 13 oz. pour tout le contour de la pièce par 5" de large. 3 fois le sac à vide Strechlon 200. 3 fois le film perforé P-3 3 fois le feutre de drainage 2 fois le tissu à délaminer (non nécessaire lors du bagging du core).</p> <p>Date: <u>7-04/14</u> Sceau: </p>		
15.0	AMB0286	Catalyst N° DDM-9
Comment Qty.: 0.0130 GALLON(s)/Unit Total: 0.0130 GALLON(s) Catalyst N° DDM-9 N° de Lot: <u>1-27829-1</u>		
16.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.
Comment Qty.: 0.360 KILOGRAMME(s)/Unit Total: 0.360 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: <u>1-45606-1</u>		
17.0	PREP-GENERAL	Préparation du matériel
 		
Comment Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs Faire la préparation de la résine selon les quantités requise, mix ratio 1.5% de catalyst N° DDM-9 par quantité de résine N° 411-350. Date: <u>9/05/14</u> Sceau:  		
18.0	LAMINAGE	Faire le laminage
 		
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Laminer la pièce selon IF134-0007. Date: <u>9/05/14</u> Sceau:  		
19.0	BAGGING	Faire le bagging sur la pièce
 		
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Faire la poche à vide selon IG 0012. Laisser sécher pendant 4 heures minimum. Heure Curing début: <u>11:15</u> Heure Curing Fin: <u>4:15</u> Date: <u>9/05/14</u> Sceau:  		

Date: Mercredi, 2014-04-16 08:14:00

Utilisateur: marc dubé

Feuille de Procédé

Client: DART US. DART AEROSPACE

Nom Dessin: N° D2445, AFT BAGGAGE DOOR

Numéro Job: 61090

Numéro DKC134-0013

Numéro Job:



Séq.: Machine ou Opération: Description :

20.0 AMB0286 Catalyst N° DDM-9

Comment Qty.: 0.0042 GALLON(s)/Unit Total : 0.0042 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-27829-1

21.0 AMB0212 Résine (411B7530) 411-350 promo. 75min.

Comment Qty.: 0.120 KILOGRAMME(s)/Unit Total : 0.120 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-45003-1

22.0 PREP-GENERAL Préparation du matériel



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préparation de la résine selon les quantités requise, mix ratio 1.5% de catalyst N°
DDM-9 par quantité de résine N° 411-350, Imbiber toutes les surfaces du Foam Core
selon IG0105.

Date: 1 Sceau:

23.0 AAC1611 Polybond B46F

Comment Qty.: 0.045 KIT(s)/Unit Total : 0.045 KIT(s)
Polybond B46F N° de Lot: 1-38189-1

24.0 DKC134-0029 Foam Core N° D2445-101 (Pour AFT Baggage Door)

Comment Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)
Foam Core N° D2445-101 (Pour AFT Baggage Door) N° de Job: 61090

25.0 ASSEMBLAGE Assemblage mécanique



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Coller le Foamcore selon IF124-0007.

Date: 12-05-14 Sceau:

26.0 BAGGING Faire le bagging sur la pièce



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la poche à vide selon IG 0012

















Retirer le bagging avant la fin de la polymérisation (entre 1h et 1h30) afin d'enlever le
surplus de Polybond.

Heure début Curing: 9:25 Heure Fin Curing: 11:30Date: 12-05-14 sceau:

Date: Mercredi, 2014-04-16 08:14:00

Utilisateur: marc dubé














Feuille de Procédé

Client:	DART US DART AEROSPACE	Nom Dessin:	N° D2445, AFT BAGGAGE DOOR
Numéro Job:	61090	Numéro	DKC134-0013
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
27.0	AMB0286	Catalyst N° DDM-9	
Comment	Qty.: 0.1360 GALLON(s)/Unit Total : 0.1360 GALLON(s) Catalyst N° DDM-9 N° de Lot: <u>1-27829-1</u>		
28.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.	
Comment	Qty.: 0.360 KILOGRAMME(s)/Unit Total : 0.360 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: <u>1-45606-1</u>		
29.0	PREP-GENERAL	Préparation du matériel	
			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% de catalyst N° DDM-9 par quantité de résine N° 411-350. Date: <u>13-05-14</u> Sceau:  		
30.0	LAMINAGE	Faire le laminage	
			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Faire le laminage des tissus de verre selon IF134-0007. Date: <u>13-05-14</u> Sceau:  		
31.0	BAGGING	Faire le bagging sur la pièce	
			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Faire la poche à vide selon IG 0012 Laisser sécher pendant 4 heures minimum. Heure Curing Début: <u>8-45</u> Heure Curing Fin: <u>8-00</u> Date: <u>17-05-14</u> Sceau:  		
32.0	DÉMOULAGE	Démoulage de la pièce	
			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Démouler la pièce en faisant bien attention aux coins & rebords. Date: <u>17-05-14</u> Sceau: 		

Date: Mercredi, 2014-04-16 08:14:00

Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE	Nom Dessin: N° D2445, AFT BAGGAGE DOOR	
Numéro Job: 61090	Numéro: DKC134-0013	
Numéro Job: 		
# Séq.:	Machine ou Opération:	Description :
33.0	TRIMAGE	Trimage
 		
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Tailler la pièce selon IF134-0006. Date: 14/05/14 Sceau: 		
34.0	AAC1492	N° P-15-3, Adtech Micro Ultra Filler
Comment Qty.: 0.014 GALLON(s)/Unit Total : 0.014 GALLON(s) N° P-15-3, Adtech Micro Ultra Filler # de Lot: 1-45373-1		
35.0	FINITION	Finition Générale
 		
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Faire les réparations de finition s'il y a lieu à l'aide du "Filler" P15-3. Date: 14-05-14 Sceau: 		
36.0	AAC1021	Dupont Primer N° 7704S
Comment Qty.: 0.0280 UNITE(s)/Unit Total : 0.0280 UNITE(s) Dupont Primer N° 7704S N° de Lot: 1-43178-2		
37.0	AAC1101	N° 7775S, Dupont Activator - Reducer Chromabase
Comment Qty.: 0.0280 UNITE(s)/Unit Total : 0.0280 UNITE(s) N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: 1-44063-3		
38.0	PRIMER	Application primer
 		
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Faire la préparation et l'application du primer batisseur selon I.G. 0008 Date: 15/05/14 Sceau:  # de fiche de mélange: 6604		
39.0	AAC1492	N° P-15-3, Adtech Micro Ultra Filler
Comment Qty.: 0.014 GALLON(s)/Unit Total : 0.014 GALLON(s) N° P-15-3, Adtech Micro Ultra Filler # de Lot: 1-45373-1		
40.0	FINITION	Finition Générale
 		
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Faire les réparations de finition s'il y a lieu à l'aide du "Filler" P15-3. Date: 16/05/14 Sceau: 		

Date: Mercredi, 2014-04-16 08:14:00

Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE

Nom Dessin: N° D2445, AFT BAGGAGE DOOR

Numéro Job: 61090

Numéro DKC134-0013

Numéro Job:



Séq.: Machine ou Opération: Description :

41.0 AAC1605 Label N° D0588-041

Comment Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)
Label N° D0588-041 N° de Lot: 1-45570-1

42.0 AAC1609 Surface Veil

Comment Qty.: 0.07 VERGE(s)/Unit Total: 0.07 VERGE(s)
Surface Veil N° de Lot: 1-45570-1

43.0 AAC1220 Résine Mia-Poxy 100

Comment Qty.: 0.007 GALLON(s)/Unit Total: 0.007 GALLON(s)
Résine Mia-Poxy 100 N° de Lot: 1-30095-4

44.0 AAC1221 Durcisseur 95 Pour Résine Mia-Poxy

Comment Qty.: 0.007 QUART(s)/Unit Total: 0.007 QUART(s)
Durcisseur 95 Pour Résine Mia-Poxy N° de Lot: 1-34505-1

45.0 ASSEMBLAGE Assemblage mécanique



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Coller le label N° D0588-041 selon IG 0111.

Date: 16/05/14 Sceau:



46.0 AAC1021 Dupont Primer N° 7704S

Comment Qty.: 0.0280 UNITE(s)/Unit Total: 0.0280 UNITE(s)
Dupont Primer N° 7704S N° de Lot: 1-54556-3

47.0 AAC1101 N° 7775S, Dupont Activator - Reducer Chromabase

Comment Qty.: 0.0283 UNITE(s)/Unit Total: 0.0283 UNITE(s)
N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: 1-44895-1

48.0 PRIMER Application primer



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Faire la préparation et l'application du primer final selon I.G. 0008

Date: 20-05-14 Sceau:



de fiche de mélange: 6604

49.0 INSPEC FINAL Inspection finale



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Faire l'inspection selon le dessin N° D2445.

Date: 22/05/14 Sceau:



Date: Mercredi, 2014-04-16 08:14:00

Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE

Nom Dessin: N° D2445, AFT BAGGAGE DOOR

Numéro Job: 61090

Numéro DKC134-0013

Numéro Job:



Séq.:

Machine ou Opération:

Description :

50.0

EMBAL / ENTREPO

Emballage & Entreposage



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire l'emballage des pièces selon IG 0057

23 MAI 2014

Date: _____ Sceau: _____



JUN 04 2004

3.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-588-011	1.0 lb	-21.0 in	-21.0 in-lb	+170.0 in	+170.0 in-lb
Aft Door Fwd Hinge Modification Kit	0.45 Kg	-0.53 m	-0.24 m-Kg	+4.32 m	+1.96 m-Kg
D350-588-041*	2.0 lb	-21.0 in	-42.0 in-lb	+170.0 in	+340.0 in-lb
Aft Door Assembly	0.91 Kg	-0.53 m	-0.48 m-Kg	+4.32 m	+3.93 m-Kg

* D350-588-041 Aft Door Assembly weight in excess of standard Eurocopter Door.

3.4 PARTS LISTS

588 -041	588 -011	Part Number	Description
X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MODIFICATION KIT
1	1	D2143	HINGE DOUBLER
1	1	D2144	HINGE DOUBLER
2	2	D2150	HINGE PACKER
2	2	D2151	HINGE DOUBLER
1	1	D2153-3315-10	GAS SPRING ASSY.
1	1	D2154	STUD BRACKET
2	2	D2237	STRIKER PLATE
1		D2445	DOOR
	1	D2461-0870	NEOPRENE D SEAL
1	1	D2463-0870	1/2" FOAM SEAL
	2	D2583	LATCH BRACKET
2	2	D2585	LATCH CLAMP
2	2	D2586	LATCH
	1	D2587	PLUG
1	1	D2589	KEYS, KEY CHAIN
2		D2621	LATCH PLATE
	1	D2690-17	CABLE, DOOR STOP
	1	D2857-1	LOWER HINGE BRACKET
	1	D2857-2	UPPER HINGE BRACKET
1	1	D2858-1	LOWER HINGE BRACKET
1	1	D2858-2	UPPER HINGE BRACKET
8	8	AN526C832R8	SCREW (or AN526-832R8)
8	8	AN526C832R9	SCREW (or AN526-832R9)
2	2	AN526C1032R7	SCREW (or AN526-1032R7)
24	24	AN960JD8	WASHER
4	4	AN960JD10	WASHER
12	12	MS20426AD3-4	RIVET
18	18	MS20470AD4-5	RIVET
18	18	MS21042L08	NUT (or MS21042-08)
4	4	MS21042L3	NUT (or MS21042-3)
2	2	MS27039-1-15	SCREW
2	2	MS27039-0811	SCREW
1	1	N/A	1 SQUARE-ft. OF 9-oz. GLASS CLOTH (S-CLASS)

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Revision: D

Date: 02.01.17

JUN 04 2014

DAS
06
9-89**3.0 PARTS LIST:**

The part lists of D350-588 Rev. D and ICA-D350-588 Rev. 0 are amended as follows.

IS:**REFERENCE ONLY**

588 -041	588 -011	PART NUMBER	DESCRIPTION
X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MOD
2	2	D5080-041	STRIKER PLATE ASSY (AS355 N/NP MODELS ONLY)
2	2	D2237	STRIKER PLATE

WAS:

588 -041	588 -011	PART NUMBER	DESCRIPTION
X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MOD
2	2	D2237	STRIKER PLATE

Customers who need to upgrade a D350-588-011/-041 kit that has been previously purchased from Dart can procure the DSI 9690-011 Kit from Dart.

QTY -011	PART NUMBER	DESCRIPTION
X	DSI 9690-011	STRIKER PLATE MODIFICATION KIT
2	D5080-041	STRIKER PLATE ASSEMBLY

4.0 WEIGHT AND BALANCE:

This DSI has a negligible effect on Weight and Balance of the aircraft.

5.0 MAINTENANCE:




Maintain the D5080-041 Striker Plates in accordance with the procedures for the D2237 Striker Plates as outlined in ICA-D350-588.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 14.03.24
CERT. NO.: SH92-41
ISSUE NO.: 8

DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9690	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		STRIKER PLATE MOD	NTS
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